

Date: Tuesday, 4/17/2007 11:11:24 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY  
 Job Number : 31856  
 Estimate Number : 10699  
 P.O. Number : *N/A* Part Number : D3391025  
 This Issue : 4/17/2007 S.O. No. : *N/A* Drawing Number : D3391 REV F  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : F  
 Previous Run : 31855 Material : *N/A*  
 Due Date : 5/10/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : *[Signature]* 07.04.17  
 Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC  
 Est Rev: C 06-03-28 Update Manufacturing Instructions  
 JLM  
 est rev D 07.03.20 revF dwg ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion *B26546*

Identify as D3391-3

*S.F. 07/04/22*

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: *F* & Dwg D3391 Rev: *AA*
*S.F. 07/04/22*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*S.F. 07/04/22*

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: *AA* & Dwg D3391 Rev: *F*

2-Deburr

*S.F. 07.06.09* (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 31856

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SG 67-06-09 ①

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

IL 07/06/10

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 7-6-13

8.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

EL 7-6-14

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE/DP 7-6-14

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open up all wearshoe & wearplate and float bag holes to .257" + countersink as per Dwg D3391.

6-Deburr

DP 7-6-25  
DP 7-6-26

Tools: rill

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Job Number: 31856

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ep 07/06/23 (X1)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HJ 07-07-19 X1

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 104/144

B/m 07-07-19 (1)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FJ 07/07/23 (1)

15.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number

Description Batch

1

D2646

Aft Cap

B 30119

m.d

16.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

B 33 227 07/07/30

17.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

B 31911

m.d

18.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B 31400

07/07/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Gasket

B 32745 m.l

20.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)  
Insert

Pick:

Qty Part Number Description Batch  
14 AESS10KB366 Insert

M104192

m.l

21.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
INSERT

Pick:

Qty Part Number Description Batch  
2 AESS10KB316 Insert  
or NAS1330C3KB316

M17905

m.l

22.0

AESS10KB266

INSERT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
INSERT

Pick:

Qty Part Number Description Batch  
6 ~~2~~ AESS10KB266 Insert  
or NAS1330C3KB266

M107905

m.l

23.0

NAS1330C3KB166

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
INSERT

Pick:

Qty Part Number Description Batch  
12 ~~8~~ NAS1330C3KB166 Insert

M102849

m.l

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31856

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch  
2 AN3C4A Bolt

M104955

m-h

25.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M104118

m-h

26.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty Part Number Description Batch  
2 AN960C10L Washer

M105057

m-h

27.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch  
2 NAS1515H3L Washer

M104603

m-h

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

M104732

07-10

m-h 07/07/24

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

In \* - checked inserts on 07/07/23

Johnston

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/09/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 31856

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PIP

33526

6 7/7/30

31.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

207/07/31

Job Completion



W 07-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31856
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> <del>E</del> F PH 07.04.17	<b>Page 1 of 1</b>

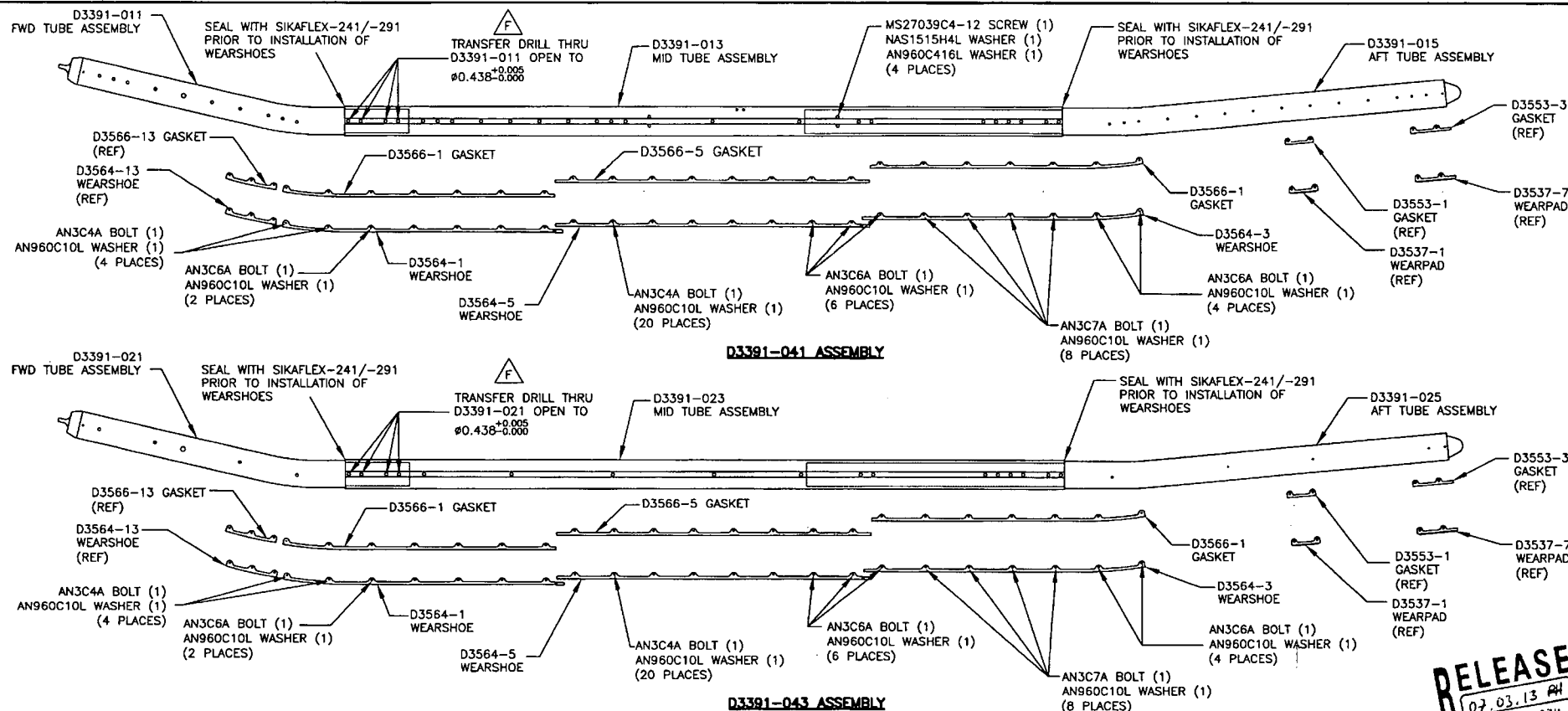
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.505	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	44.995				
3.200	+/-0.010	3.200	✓			
1.526	+0.000/-0.030	1.522	✓			
0.200	+/-0.010	.200	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
0.400	+/-0.010	.4000	✓			
<del>Ø0.208</del>	<del>+0.005/-0.004</del>					
3.300	+/-0.010	3.302	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.522	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.486	✓			

<b>Measured by:</b> J.B. KSG	<b>Audited by:</b> J.L.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/04/17	<b>Date:</b> 07/06/17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	



#### D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
	1	D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

#### GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C/SINK Ø0.391/Ø0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

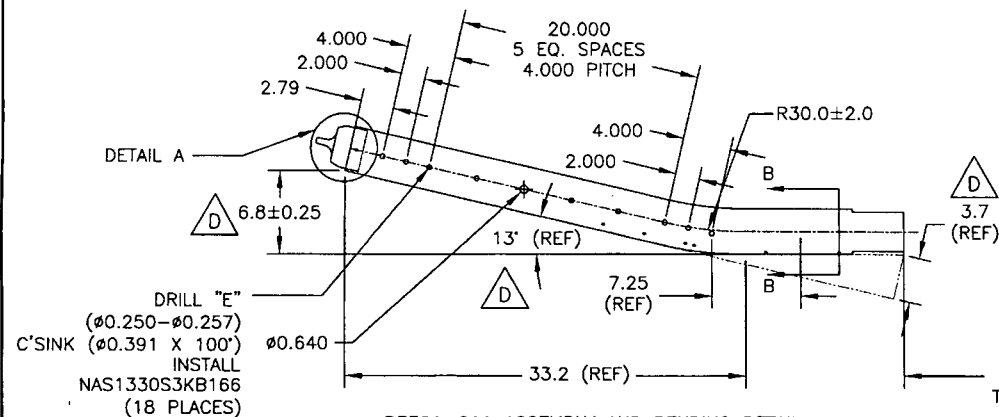
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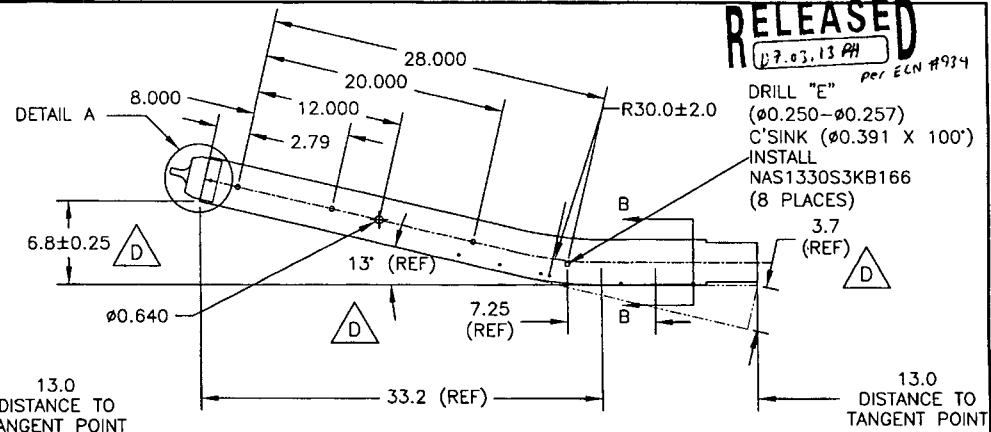
F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	07.01.18	TITLE 412 FLOAT SKIDTUBE
		DART AEROSPACE USA, INC. REV. F SHEET 1 OF 5 SCALE NTS

NO. 21857  
WORK ORDER  
SUBJECT TO AMENDMENT  
CONTROLLED COPY  
RETURN TO  
SHOP COPY

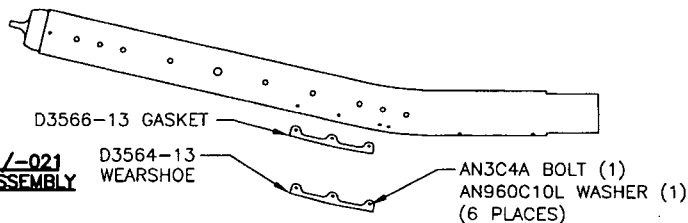
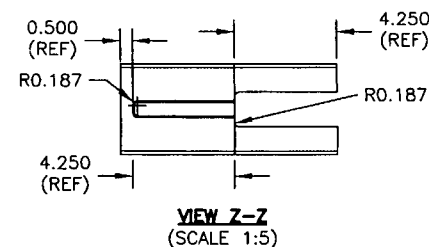
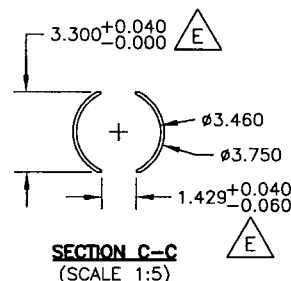
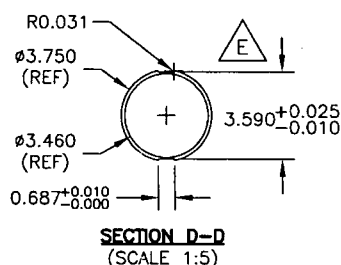
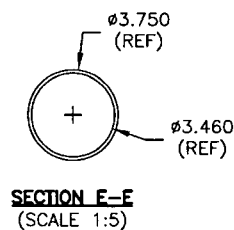
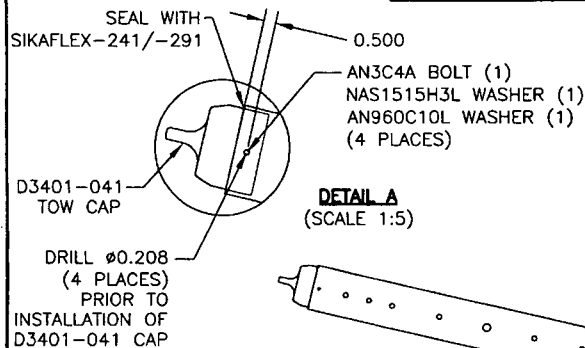
**RELEASED**  
 17.03.13 AH  
 per ECN #974



**D3391-011 ASSEMBLY AND BENDING DETAIL**



**D3391-021 ASSEMBLY AND BENDING DETAIL**



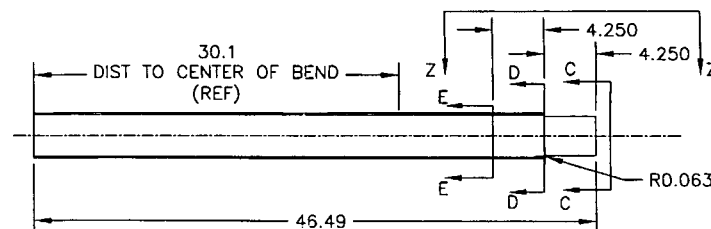
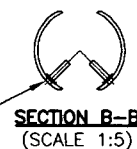
**D3391-011/-021 WEARSHOE ASSEMBLY**

**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

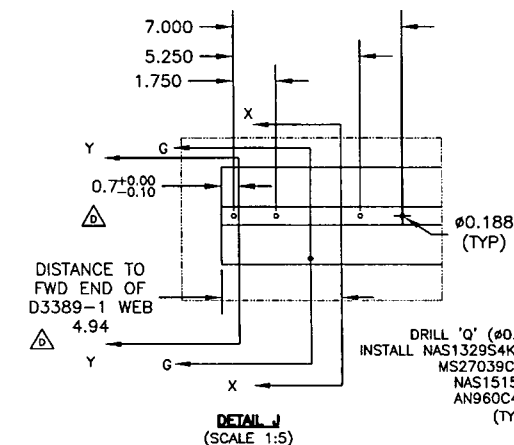
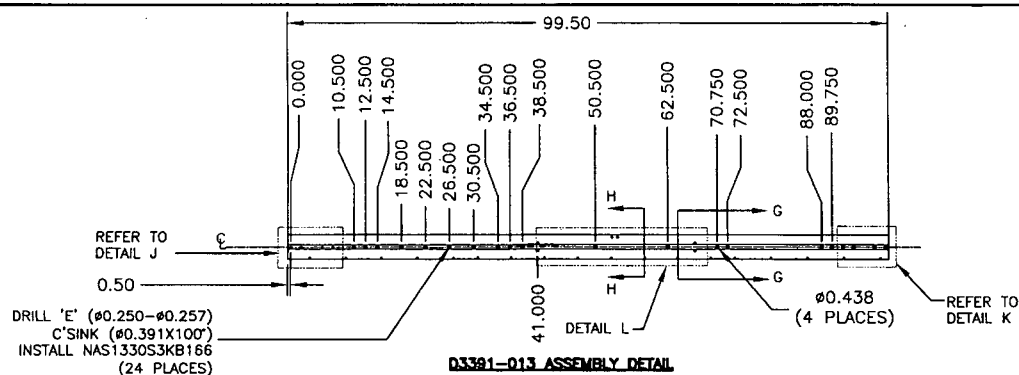
NO. 31852  
 WORK ORDER  
 SUBJECT TO ATTACHMENT  
 WITHOUT NOTICE  
 UNCONTROLLED COPY  
 RETURN TO  
 SHOP COPY  
 ENGINEERING

5  
 DRILL 'E'  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100')  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

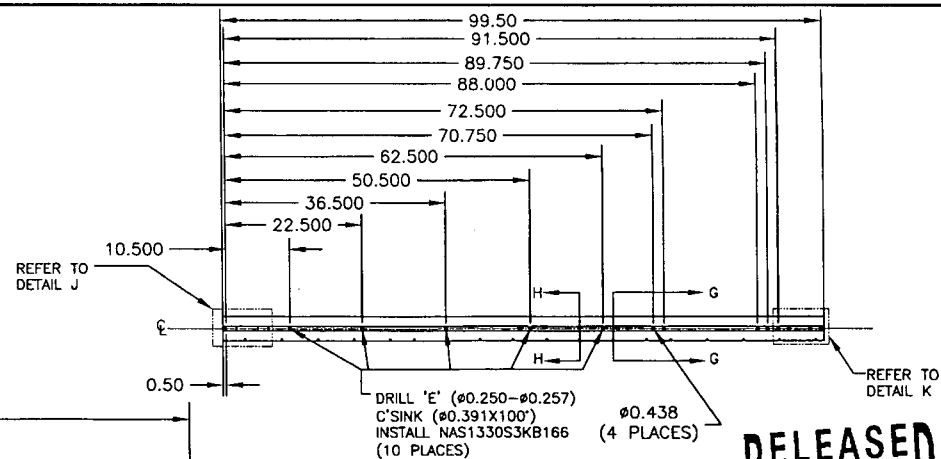


**D3391-1 DRILLING AND CUTTING DETAIL**  
 (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

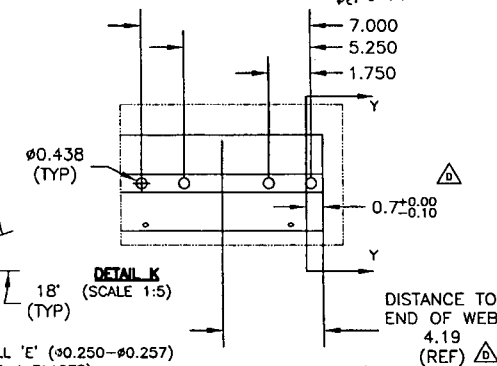
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.		DESIGN PH	DRAWN BY AH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED JH	APPROVED JH	DRAWING NO. D3391		REV. F SHEET 2 OF 5
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		SCALE 1:10



DRILL 'Q' (Ø0.332-Ø0.338)  
INSTALL NAS1329S4KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



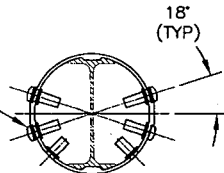
**D3391-023 ASSEMBLY DETAIL**



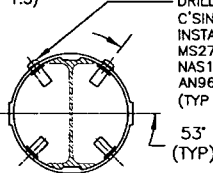
**D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

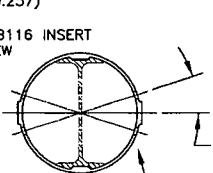
**SECTION L-L (SCALE 1:4)**



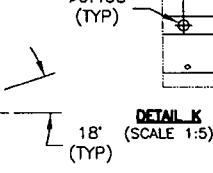
**SECTION M-M (SCALE 1:4)**



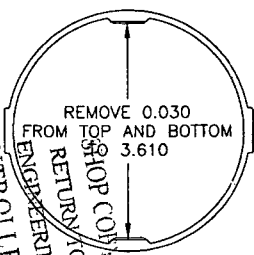
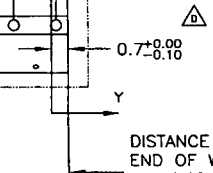
**SECTION LL-LL (SCALE 1:4)**



**SECTION G-G (SCALE 1:4)**



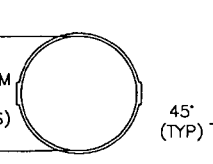
**SECTION H-H (SCALE 1:4)**



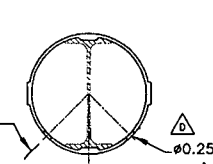
**SECTION X-X (SCALE 1:2)**

REMOVE 0.225 FROM TOP AND BOTTOM TO 3.800 (0.7 FROM BOTH ENDS)

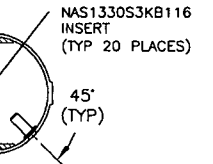
**SECTION Y-Y (SCALE 1:4)**



**SECTION G-G (SCALE 1:4)**



**SECTION H-H (SCALE 1:4)**



**D3391-013/-023 MID TUBE ASSEMBLY**

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

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WORK ORDER  
NO 31856

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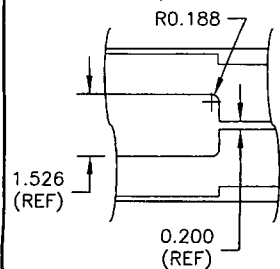
DESIGN  
CHECKED  
DATE  
07.01.18

DRAWN BY  
APPROVED  
TITLE  
412 FLOAT SKIDTUBE

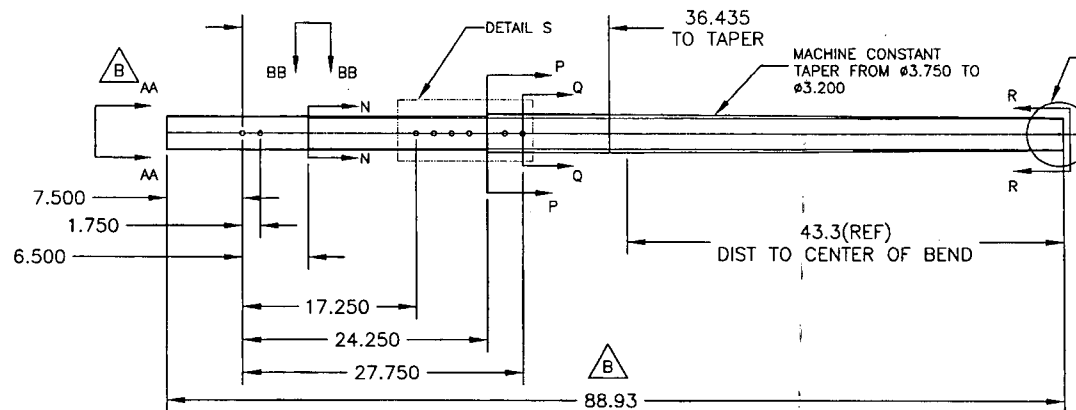
DART AEROSPACE USA, INC.  
PORT HADLOCK, MA  
DRAWING NO.  
D3391  
REV. F  
SHEET 3 OF 5  
SCALE  
1:20

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07.05.13 PH  
Per ECU #934

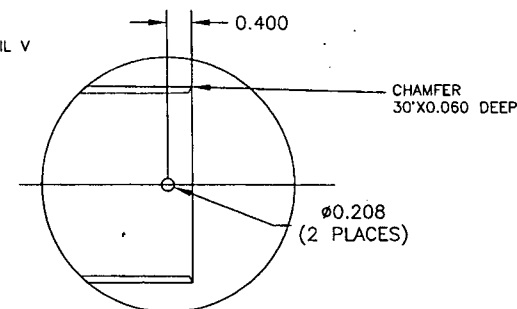




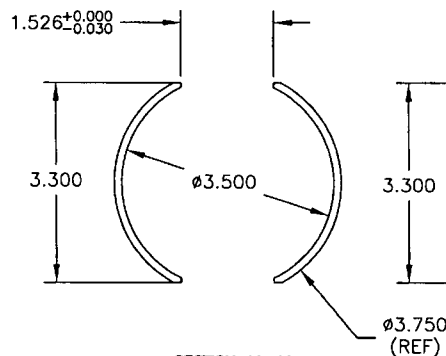
VIEW BB-BB  
(SCALE 1:3)



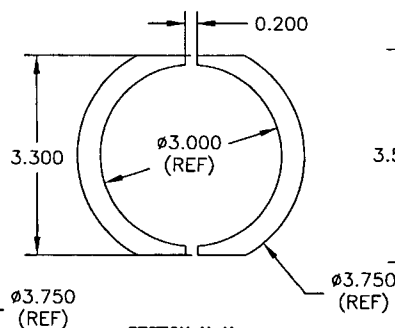
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



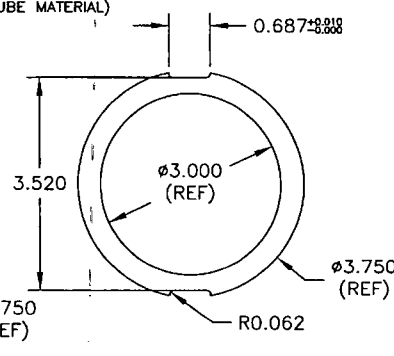
DETAIL V  
(SCALE 1:2)



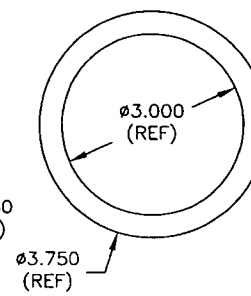
SECTION AA-AA  
(SCALE 1:2)



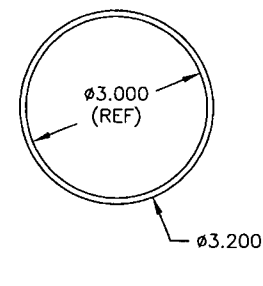
SECTION N-N  
(SCALE 1:2)



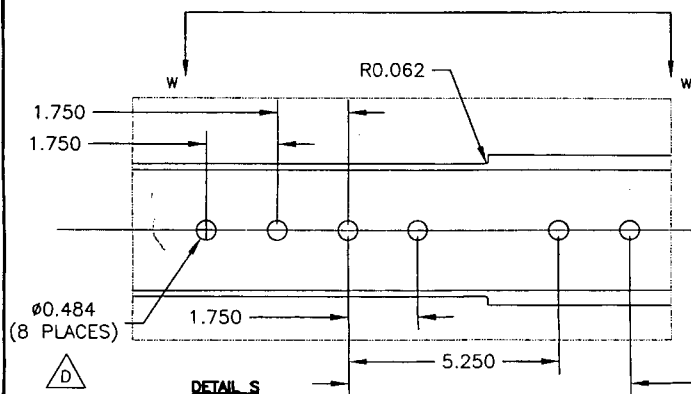
SECTION P-P  
(SCALE 1:2)



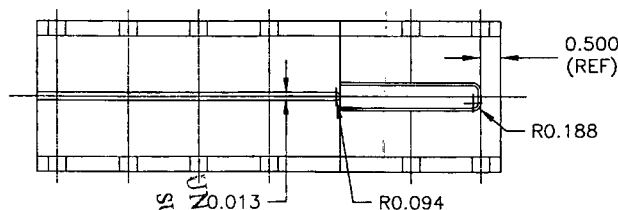
SECTION Q-Q  
(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



DETAIL S  
(SCALE 1:3)



VIEW W-W  
(SCALE 1:3)

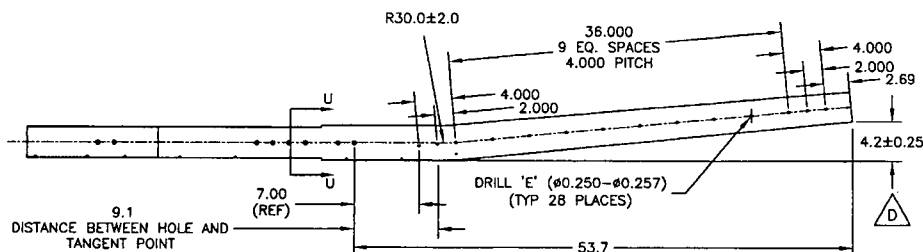
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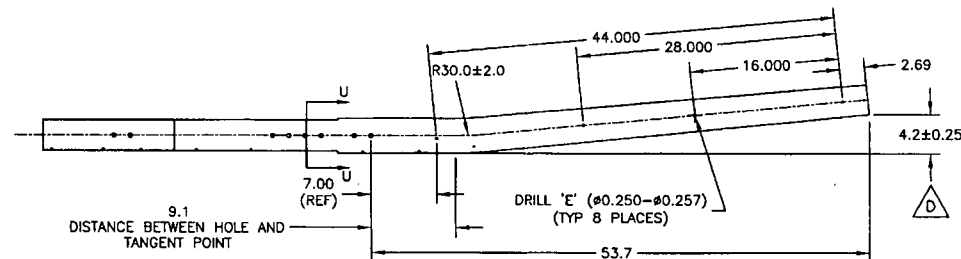
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CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	

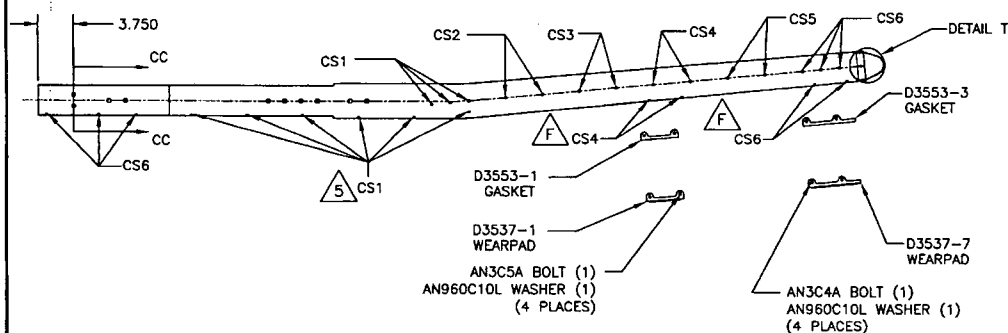
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07 03.13 PH  
per ECU #934



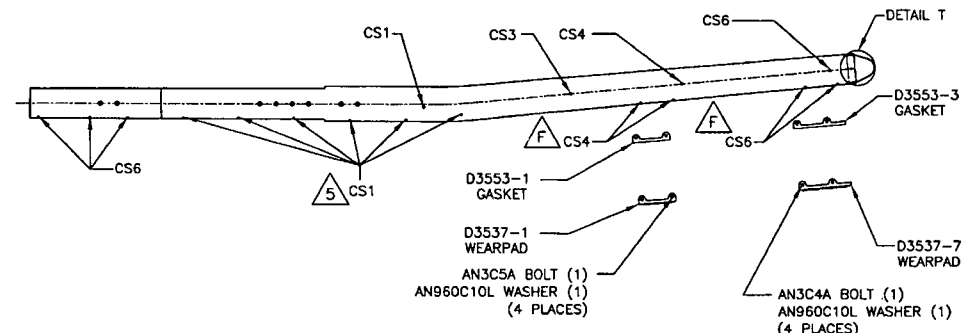
**D3391-015 BENDING AND ASSEMBLY DETAIL**



**D3391-025 BENDING AND ASSEMBLY DETAIL**



**D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)



**D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)

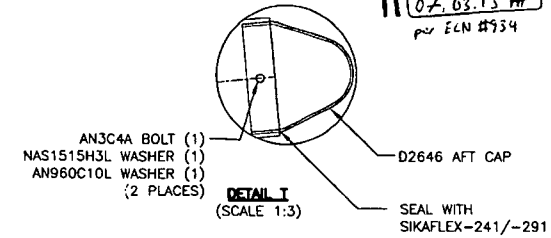
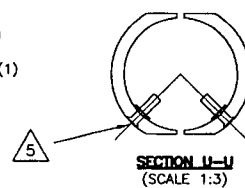
**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

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DRILL 'Q' (#0.332-#0.338)  
C'SINK (#0.529X100)  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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